

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027600**Date Inspected:** 12-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

In Process Visual Inspection

Tower

Request For Information: ABF-RFI-002667R00

“Multiple Shear Tabs were removed, due to interference during the 9m and 13m Diaphragm erection, which provide a bolted connection between the Diaphragms and Shear Plates...”

This QA randomly observed ABF/JV qualified welder Jeremy Dolman #5042 performing Shielded Metal Arc Welding (SMAW) with 3.2 diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-1160. This work was located on Shear Tabs #1 and #2 at the 13m elevation at location “E/F”.

During welding, ABF Quality Control (QC) Bernie Docena was noted monitoring the welding parameters. Welding parameters were recorded as (A=130).

This QA randomly observed ABF/JV qualified welder Jeremy Dolman #5042 performing Shielded Metal Arc Welding (SMAW) with 3.2 diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-1160. This work was located on Shear Tabs #1 and #2 at the 13m

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elevation at location "G/H".

During welding, ABF Quality Control (QC) Bernie Docena was noted monitoring the welding parameters. Welding parameters were recorded as (A=130).

Electroslag Weld Excavations

This QA randomly observed ABF/JV welding personnel performing excavation of welds previously Magnetic Particle Test (MT) rejected. Quality Control (QC) Inspector Jesse Cayabyab performed continued Magnetic Particle (MT) and visual confirmation of excavations.

Excavations were recorded as follows:

Weld "P" – Y=2420mm, L=14900mm, W=11mm, D=7mm

This QA observed, at random intervals, ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1001-Repair. The joint being welded was tower shear plate designated as ESW weld, location "J" from face "A".

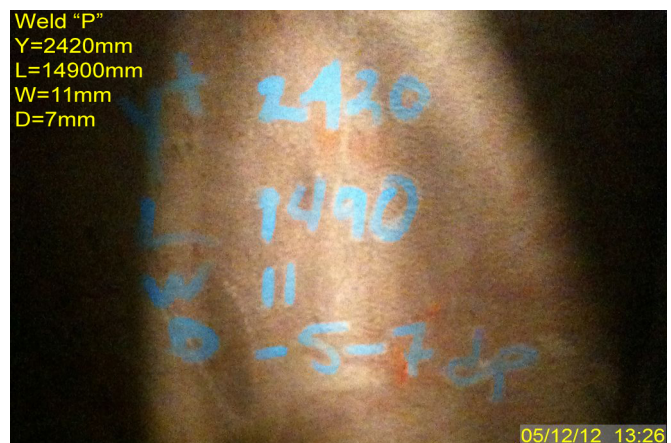
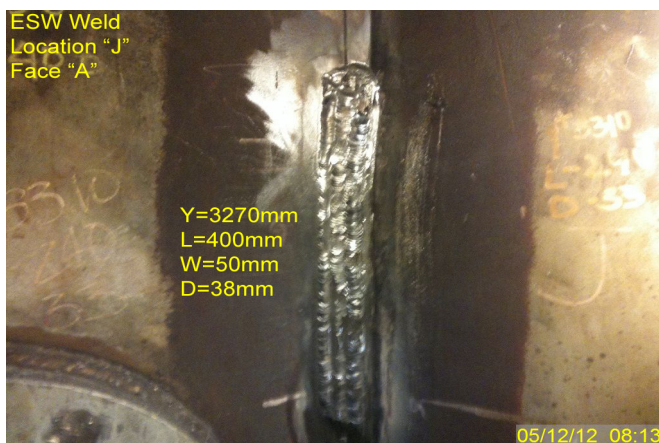
Dimensions excavated for this repair were: (Y=3270mm, I=400mm, W=50mm, D=38mm)

During welding, ABF Quality Control (QC) John Pagliero was noted monitoring the welding parameters. Welding parameters were recorded as (A=131).

Note:

At approximately 8:35am tower welding operations experienced a loss of electrical power. All ABF/JV welding personnel were ordered out of all confined spaces until power could be restored. Electrical power was restored at approximately 8:45am and welding operations commenced.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William
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Quality Assurance Inspector

Reviewed By:	Levell, Bill
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QA Reviewer
